

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021409**Date Inspected:** 13-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Geng Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

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This QA Inspector observed the following work in progress: Shielded Metal Arc Welding (SMAW) of OBG segment 13BE bottom panel to floor beam weld, SEG3009J-100. ZPMC welder was identified as 020096. ZPMC CWI was identified as Geng Wei. The welding appeared to be in conformance with ZPMC weld repair report B-WR 20096 and welding procedure specification, WPS-345-SMAW-2G(2F)-FCM-Repair-1.

Shielded Metal Arc Welding (SMAW) of OBG Segment 13CE side panel to vertical plate weld, SEG3001U-002. ZPMC welder was identified as 066258. ZPMC CWI was identified as Chen Xi. The welding appeared to be in conformance with ZPMC Critical Weld Repair report B-CWR 2648 and welding procedure specification, WPS-345-SMAW-2G(2F)-FCM-Repair.

This QA Inspector performed Ultrasonic Testing (UT) verification of welds previously tested and accepted by ZPMC for OBG Segment 13AE welds. See MT report TL-6027 generated this date for additional information. The following welds was tested:

SEG3007V-010, 069, 198

SEG3007AT-095

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SEG3007-197 was visually rejected by ZPMC QC Wang Xu for weld profile and and non compliant cope holes. Mr. Wang stated these areas would be repaired and resubmitted by ZPMC for Caltrans QA verification.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation between QA and QC occurred this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
